Work Order ID 75970  November-02-11 10:45:28 AM			*75970*								Page 1	
Item ID: Revision ID:	D3262-043			Accept	*N900	0040	100	)*	Setup S		*N:	S1*
Item Name:	Canister Assem	nbly								Stop	*N	S2*
Start Date:	02/11/2011	Start Qty: 2.00	*2*		Cust Item	ID:						
Required Date:	16/11/2011	<b>Req'd Qty:</b> 2.00	*2*		Customer:							
Reference:			,									
Approvals:			Date: 11/11/02		D	ate:				tart Stop	*NI	R1*
	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:			^	лор	*NI	R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		ject ımber	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3262	Е					* 1						
100			minum rod Batch: WA	0.00		1),			/			·
*100*		Large Fab				11.12	25	2	$\mathscr{D}$			
Large Fab		Memo		0.00		11'12	00		7			
Large Fab		Weld canis	ter assembly as per Dwg D326	52 using DT8739 to alig	n fittings							
110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00								
*110*								$\mathcal{A}$	E)	,	RE11.	12-06
QC		Memo		0.00							<u> </u>	122 04
Quality Control												
120		QC5- Inspect part compl	leteness to step on W/O	0.00								
*120*			-	< .	1				_			
QC		Memo		0.00 S N/1	2/06			-(~	<del>-2)</del>			~~
Quality Control		Pressure tes	t as per Dwg D3262		*			_	_			

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W/O:		, <u>" </u>	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1 Tod Wigi	
		·							
									·
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQA	<b>\:</b>	Date:	
	R	esolution:	Disposition	on:	_ QA: N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)			
	0750	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
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		·							
							•		
	1	1	1 1			4			

Work Order ID 75970  November-02-11 10:45:28 AM			*759	770*					Page 2	!	
Item ID: Revision ID:	D3262-043			Accept	*N900	<b>040</b>	100	* Set	tup Start	IAT	
Item Name:	Canister Asse	mbly							Stop	*NS2*	
Start Date:	02/11/2011	Start Qty: 2.00	*2*		Cust Item I	D:					
Required Date: Reference:	16/11/2011	Req'd Qty: 2.00	*2*		Customer:				~		
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ate:	-	Ru		*NR1*	
••	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NR2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #				Reject Insp. Number Stamp	
130		Chemical Conversion C	oat per QSI005 4.1	0.00			^		1.1	1	1
*130* HandFinish Hand Finishing		Мето		0.00			$\mathcal{A}_{\bar{z}}$	XJ	M	1/12/	06
140		White Gloss(Ref:4.3.5.1	) per QS1005 4.3-Alum	0.00			$\triangle$	V -1		/ / /	
*1 <b>4</b> 0*							$\propto$	$X \mathcal{J}$	M-	L4/12/c	) [
Powder Coating		Memo	to mask threads ***	0.00							,
Powder Coating	1480	START TIN OVEN TEN FINISH TIN	ME: Z	2001							
150		QC3- Inspect Part Finish	1	0.00				a	120		
<u>*150*</u>				0.00			2	<u>/</u>	DK /1	-12-7.	
QC		Memo		0.00					·		

Quality Control

W/O:			W	ORK ORDER CHANG	GES			• • • • • • • • • • • • • • • • • • • •
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Prod Nigi	
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes 1	lo DQA:	Date: _	
	Re	esolution:	Dispositi	on:	QA: N/C Clo	sed:	Date: _	
NCR:		,	WORK ORI	DER NON-CONFORM	IANCE (NCR)			
D.475		Description of NC	Description of NC Corrective			Verification	Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector
			1					
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Work Order ID 75970  November-02-11 10:45:28 AM		*75970*						Page 3	
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3262-043  Canister Asse 02/11/2011 16/11/2011	mbly Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*	Accept	*N9000  Cust Item ID  Customer:		<b>)*</b> Setu	p Start Stop	*NS1* *NS2*
Reference: Approvals:	Process Pla		Date:	Tooling: _ SPC (Y/N):	Dat		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 160 *160* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ock Location: 144	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Qty Q	ty	Reject Insp. Number Stamp
170 *170* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00				nl	12/8 W

	•								
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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·									
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	Res	solution:	Disposition	on:	_ QA: N/C	Closed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORMA	ANCE (NC	R)			
DATE	OTED	Description of NC			ion B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti		Chief Eng	QC Inspector
				<del></del>				· · · · · · · · · · · · · · · · · · ·	

#### **Picklist Print**

November-02-11 10:45:32 AM

Work Order ID: 75970

\*75970\*

Parent Item:

D3262-043

\*D3262-043\*

Parent Item Name: Canister Assembly

Start Date: 02/11/2011

**Required Date:** 16/11/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

**Comments:** 

IPP rev A 10.01.19 new issue EC verified by: DD as per ECN10-571 DD 10.05.10 verified :EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3262-1 *D3262-1* Tube		Manufactured	No	_B	75196	₹2	Each	0.0000	**	2	H11.1	2.06	,
Tube D3262-5 *D3262-5* Cap		Manufactured	No			100	Each	5.0000	<b>**</b>	4	Q11.1	2.00	o
				Location LG002	ニーイグベ	4 <u>Loc (</u>	<b><u>Oty</u></b> 5 5	Loc Code	_	3	_ _		

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	ory:	_ NCR: Ye	s No D	QA:	Date: _	
	Reso	olution:	Disposition	:	_ QA: N/C	Closed: _		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (NO	CR)			
		Description of NC	Corrective Action		ection B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&∣ <sub>Se</sub>	ection C	Chief Eng	QC Inspector
									<b>t</b>
							···		

3 2 QTY -041 ITEM P/N DESCRIPTION D3262-041 X CANISTER ASSEMBLY D3262-1 TUBE D3262-3 SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 15970 M.L.J 11111/02 10.88 REF -FITTING HOLES IN LINE Ø5.17 REF

#### **D3262-041 CANISTER ASSEMBLY**

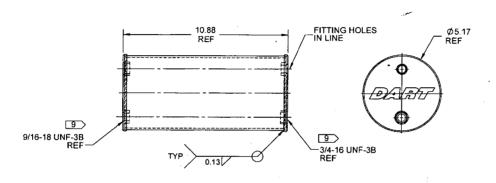
DATE	10.0	5.03	COPYRIGHT © 2004 BY DART A THIS DOCUMENT IS PRIVATE AND COMPEDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMMUNICATION WRITTEN PROMUSION FROM DART ARE	ON THE EXPRES	S CONDITION THAT IT IS			
DE APP	R.	#	FUEL PURGE CANIS		NTS			
APPRO	VED	14	TITLE		SCAL			
MFG. Al	PPR.	91	D3262		SHEET 1 OF			
CHECK	ED	45	DRAWING NO.		REV.			
DRAWN	1	RF	HAWKESBURY, ONTARI					
DESIGN	1	RF	DART AEROSPA	CEL	TD			
REV.			DESCRIPTION	BY	DATE			
Α	NEWIS	SUE	RF	04.05.06				
В	ADD P	RESSURE 1	FESTING OPTION	МВ	05.02.14			
С	Ø5.16	5 WAS Ø5.	190	RF	06.08.31			
٥	ADD D3 TO EQU 09-004	262-043/-5 (Z IAL TOOL DIN	N B5-2; B5-5); REVISE DIMENSIONS MENSIONS (ZN B2-4; C2-4) PER CAR	RF	09.12.30			
Ε	0.25 WA 5); ADD	.25 WAS 0.45 (ZNC7-4, C7-5); 0.13 WAS 0.33 (ZN B7-4, B7- ); ADD DIMENSION (ZN B1-4, D1-5, B1-5)						

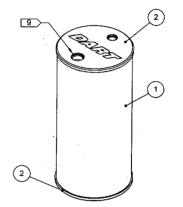
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.51 ibs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

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W/O:			WC	RK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	jory:	NCR: Y	es N	o <b>DQA</b> :	·	Date:	<del></del>
	R	esolution:	Disposition	1:	QA: N/C	Clos	sed:		Date: _	
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	Description of NC	Description of NC Corrective Action				Verifica	ition	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section	ı C	Chief Eng	QC Inspector
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	}	·								

ITEM	QTY -043	P/N	DESCRIPTION	
	Х	D3262-043	CANISTER ASSEMBLY	
1	1	D3262-1	TUBE	
2	2	D3262-5	CAP	





#### D3262-043 CANISTER ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: CHÉMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 lbs
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	RF					
CHECKED	<b>\$</b>	DRAWING NO.	REV. E			
MFG. APPR. APPROVED		D3262	SHEET 2 OF 5			
		TITLE	SCALE			
DE APPR.	4	FUEL PURGE CANISTER				
DATE 10.0	5.03	THIS DOCUMENT OF PRIVATE WHICH COMPANY AND THIS DOCUMENT OF PRIVATE WHICH COMPANY AND THIS COPPECS CONDITION THAT IT IS, NOT TO BE USED FOR ANY PLAYORS OF STATEMENT OF THE COPPECS CONDITION THAT IT IS, NOT TO BE USED FOR ANY PLAYORS OF THE PRIVATE OF THE POST OF THE POS				

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DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector		
									Prod Mgr			
									:			
***			····						91-99-41			
Part No: PAR #:			Fault Cate	_ Fault Category: NCR: Ye				R: Yes No DQA: Date:				
	Resolution: Disposition:					QA: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (	NCR)						
<b>5</b> 4		Description of NC	Corrective Action Section B				Verification Section C		Approval	Approval		
DATE	STEP Description of NC Section A		Initial Chief Eng			Sign & Date			Chief Eng	QC Inspector		
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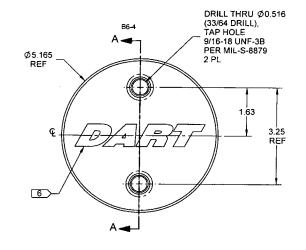
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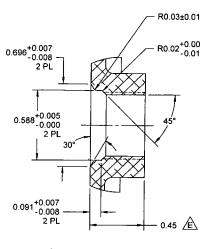
2 Ø5.00 С 0.13 REF D3262-1 TUBE NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125 REF. DART SPEC. M606T1615.0UUW.129
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. E D3262 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE DE APPR. **FUEL PURGE CANISTER** DATE 10.05.03 COPYRIGHT © 2004 BY DART AEROSPACE LTD
THE DOCUMENT'S PROVIDE AUTOCOMPENSAL LAB IS DUPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY ABOVED OF CONFIDENCE TO ANY THORSE PERSON WITHOUT METERS PROSECUE FROM ONE AND ANY ABOVED.

Dart Aerospace Ltd	
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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Y	es No	DQA	\:	Date:	
	Re	solution:	on:	QA: N/C Closed: Date:						
NCR:			WORK ORD	ER NON-CONFORM	IANCE (N	CR)				
DATE	STEP	Description of NC	NC Corrective Action			В		ation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		in & ate	Section	on C	Chief Eng	QC Inspector
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£ 0.25 Ø0.875 2 PL <sup>4</sup>Ø5.005<sup>+0.010</sup> R0.063 TYP 0.070 x 45° CHAMFER 0.080 0.13 TYP TYP





DETAIL B C7-4

SECTION A-A C5-4

D3262-3 CAP

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В

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B REF. DART SPEC. M6061168

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP

(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN

7) WEIGHT: 0.28 ibs 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA					
CHECKED	45.	DRAWING NO.	REV. E				
MFG. APPR. APPROVED		D3262	SHEET 4 OF 5				
		TITLE	SCALE				
DE APPR.	-41-	FUEL PURGE CANISTER	NTS				
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT SHEATE AND CONTRIDENTAL AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF CONCENSION ATTENDATED TO ANY OTHER PERSON WITHOUT					

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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	lo <b>DQA</b> :	Date: _	
	Resolution: Disposition: C				_ QA: N/C Clo	sed:	Date: _	
NCR:		\	VORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Section		Verification	1 Approval	Approval
DATE	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
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SED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSONS

DATE

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10.05.03

8 6 3 2  $0.091^{+0.007}_{-0.008}$ R0.03±0.01 R0.02<sup>+0.00</sup> Ø0.696<sup>+0.007</sup> D 45° Ø0.588<sup>+0.005</sup> -0.000 DRILL THRU Ø0.516 Æ 0.25 30° (33/64 DRILL). B7-5 0.45 TAP HOLE Ø5.165 9/16-18 UNF-3B REF PER MIL-S-8879 Ø0.875 2 PL DETAIL D C7-5 С 1.63 <sup>5</sup> Ø5.005 +0.010 3.25 REF R0.063 TYP 0.101+0.008 R0.03±0.01 - R0.02<sup>+0.00</sup> Ø0.882<sup>+0.008</sup>-0.007 --E A2-5 0.070 x 45° CHAMFER 0.080 0.13 E DRILL THRU Ø0.688 TYP (11/16 DRILL) TAP HOLE 3/4-16 UNF-3B Ø0.771+0.005 -0.000 Æ SECTION C-C D5-5 PER MIL-S-8879 0.45 D3262-5 CAP DETAIL E B7-5 NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN DESIGN RF DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA RF CHECKED DRAWING NO. REV. E D3262 MFG. APPR SHEET 5 OF 5 7) WEIGHT: 0.27 lbs 8) PART IS SYMMETRICAL ABOUT CENTERLINE APPROVED TITLE SCALE **FUEL PURGE CANISTER** DE APPR

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W/O:			WO	<b>RK ORDER CHANG</b>	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	_ NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	Reso	olution:	Disposition	QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	7)			
DATE	STEP Description of NC Section A	Description of NC		on B	Verific	cation	Approval Chief Eng	Approval	
DATE		Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	Section C		QC Inspector	
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